

Contents

00 - Technical data	1
1 Safety briefing/employee qualification	1
1.1 Qualification	1
2 Safety information	2
2.1 Safety information	2
2.2 Safety precautions when working on the high-voltage system	4
2.3 Safety precautions when working in the vicinity of high-voltage components	5
2.4 Safety precautions when working on the cooling system	5
2.5 Safety precautions when using testers and measuring instruments during a road test	6
2.6 Work that requires high-voltage system to be de-energised	6
3 Repair instructions	7
3.1 Important notes	7
3.2 General notes and quality-related information	7
3.3 Information on handling fine dust, aluminium dust and steel dust	9
3.4 Routing and attachment of pipes, hoses and wiring	9
3.5 Contact corrosion	10
3.6 Bonding surfaces for self-adhesive components	10
3.7 Secure threaded connections	11
3.8 Identification plates	11
3.9 Impact wrenches	11
3.10 Dent removal	12
3.11 Matching the surface contour	13
3.12 Straightening and re-alignment of body parts	14
3.13 Galvanised body panels, high-strength and extra-high-strength steel	14
3.14 Aluminium sheet panels and cast aluminium profiles	18
3.15 Procedure for accident repairs	21
4 Processing body structure adhesive D 180 004 M2	23
4.1 Preparing bonding surfaces	24
5 Renewing friction element welded joint	37
5.1 Separating friction element welds (countersunk friction elements)	42
6 Vehicle identification data	52
6.1 Vehicle identification number	52
6.2 Type plate	53
6.3 Vehicle data sticker	54
7 Repairing joints with flow-drill screws	55
7.1 Socket for flow-drill screws (alternative)	55
7.2 If replacement upper panel is supplied with pre-drilled holes	55
7.3 If replacement upper panel is not supplied with pre-drilled holes	55
7.4 Renewing upper and lower panels	56
7.5 Repair set for flow-drill screws -VAS 6631-	57
8 Extraction systems for steel/aluminium body repair station ("multi-material-mix" workplace)	58
9 Overview of attachment pairings	60
9.1 Overview of rivets and tools	61
9.2 Overview of rivets used for repair measures	67
9.3 Thread repair for M6 pop rivet nut	68
10 Tools	69
10.1 Using edge milling unit -VAS 882 005-	72
10.2 Straightening jig	104
50 - Body - front	106
1 Safety information	106

2	Overview of components	107
3	Renewing junction plate	108
3.1	Tools	108
3.2	Procedure	109
4	Renewing upper wheel housing longitudinal member	116
4.1	Tools	116
4.2	Procedure	117
5	Renewing upper wheel housing longitudinal member - part section	134
5.1	Tools	134
5.2	Procedure	135
6	Renewing support	148
6.1	Tools	148
6.2	Procedure	150
7	Renewing suspension turret	155
7.1	Tools	155
7.2	Procedure	156
8	Renewing front longitudinal member - part section	173
8.1	Tools	173
8.2	Procedure	174
9	Renewing front longitudinal member	189
9.1	Tools	189
9.2	Procedure	190
10	Renewing cowl panel	222
10.1	Tools	222
10.2	Procedure	223
11	Renewing vehicle front end	229
11.1	Tools	229
11.2	Procedure	230
51 - Body - centre		255
1	Safety information	255
2	Overview of components	256
3	Permitted separating cuts on complete side frame	257
4	Renewing carbon roof	258
4.1	Tools	258
4.2	Procedure	259
4.3	Preparing body flange for installation	262
4.4	Installing carbon roof	263
5	Renewing front roof cross member	266
5.1	Tools	266
5.2	Procedure	267
6	Renewing rear roof cross member	277
6.1	Tools	277
6.2	Procedure	278
7	Renewing roof side member	287
7.1	Tools	287
7.2	Procedure	288
8	Renewing roof side member (outer reinforcement)	298
8.1	Tools	298
8.2	Procedure	299
9	Renewing roof side member (inner reinforcement)	302
9.1	Tools	302

9.2	Procedure	303
10	Renewing outer A-pillar	307
10.1	Tools	307
10.2	Procedure	308
11	Renewing A-pillar reinforcement	318
11.1	Tools	318
11.2	Procedure	319
12	Renewing outer B-pillar	325
12.1	Tools	325
12.2	Procedure	326
13	Renewing inner B-pillar	333
13.1	Tools	333
13.2	Procedure	334
14	Renewing outer side member	345
14.1	Tools	345
14.2	Procedure	346
15	Renewing inner side member	353
15.1	Tools	353
15.2	Procedure	354
16	Renewing side member reinforcement	361
16.1	Tools	361
16.2	Procedure	362
17	Repairing side member reinforcement	373
17.1	Tools	373
17.2	Procedure	374
53 - Body - rear		385
1	Safety information	385
2	Overview of components	386
2.1	Permitted separating cuts on complete side frame	386
3	Renewing rear upper cross panel	388
3.1	Tools	388
3.2	Procedure	389
4	Renewing rear cross panel	396
4.1	Tools	396
4.2	Procedure	397
5	Renewing rear cross member	404
5.1	Tools	404
5.2	Procedure	405
6	Renewing tail light mounting	407
6.1	Tools	407
6.2	Procedure	408
7	Renewing side panel	415
7.1	Tools	415
7.2	Procedure	416
8	Renewing C-pillar reinforcement	428
8.1	Tools	428
8.2	Procedure	429
9	Renewing outer wheel housing	433
9.1	Tools	433
9.2	Procedure	434
10	Renewing rear outer wheel housing - partial renewal	440
10.1	Tools	440



10.2	Procedure	441
11	Renewing rear outer wheel housing (front section) - partial renewal	448
11.1	Tools	448
11.2	Procedure	449
12	Renewing rear longitudinal member	454
12.1	Tools	454
12.2	Procedure	455
13	Renewing rear longitudinal member - part section	494
13.1	Tools	494
13.2	Procedure	495
14	Renewing luggage compartment floor	499
14.1	Tools	499
14.2	Procedure	500